

Work Order ID 151958

Friday, October 14, 2016 1:56:05 PM

151958

Page 1

Item ID: D3319-3

Revision ID:

Item Name: Full Length Wearplate

Start Date: 10/3/2016 Start Qty: 8.00

Required Date: 10/14/2016 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Accept

Tooling:

SPC (Y/N):

N900040100

Cust Item ID:

Customer:

Setup Start

Stop

NS1***NS2***

Run Start

Stop

NR1***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3319

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3319

Dwg Rev: CProg Rev: C

2-Deburr if necessary

0.24

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

(10)

De 16/11/11

(10)

De 16/11/11

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Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Full Length Wearplate
Start Date: 10/3/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				<u>10</u>			DAS 38 9-89 NOV 14 2016
140 *140* Brake NC Brake NC	NC BRAKE Memo Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>C</u>	0.01 0.07			DAS 30 9-89	<u>10</u>			NOV 17 2016
150 *150* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>10</u>			DAS 38 9-89 NOV 17 2016

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Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Full Length Wearplate
Start Date: 10/3/2016 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 8.00 ***g*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R Hardcoat steel Batch: _____ Large Fab	0.00							
	Memo	0.39				(10)		DYC 16/11/23	
Large Fab	Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Batch A/R 7560 Hardcoat Rod <u>M135425</u>								
170 *170* QC	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 9
Quality Control	Memo	0.00				(10)	16-11-23		9-89
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							DAS 9
Quality Control	Memo	0.03				(10)	16-11-23		9-89

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Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Full Length Wearplate
Start Date: 10/3/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3 <i>m 134 858.</i> Memo START TIME: <u>11:30.</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>12:00.</u>	0.00 0.03				<u>10</u>	<u>φ</u>	<u>16-11-24.</u>	<i>DAS 34 9-89</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>10</u>			<i>DAS 38 9-89</i> NOV 25 2016
210 *210* Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-3, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: <u>ST260B</u>	0.00 0.00				<u>10</u>			<i>DAS 6 9-89</i> NOV 30 2016

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Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 10/3/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.13					DAS 21 9-89	NOV 3 0 2016	
Quality Control									

DAS
21
9-89
NOV 3 0 2016

Picklist Print

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Work Order ID: 151958

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Parent Item: D3319-3

D3319-3

Parent Item Name: Full Length Wearplate

Start Date: 10/3/2016

Required Date: 10/14/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A05.05.12New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased		No		100	sf	41.0042	3.2524	27.38863			

M1010S18GA

1010/1025 SHEET .048

De 11/11/11

Location

Loc Qty

Loc Code

MAT019

41.004152

124428

3

m130454

0.3542

m132886

10.45

m134083

10.7

m134982

6.5

m135612

10

136036

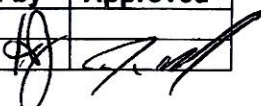
26.5

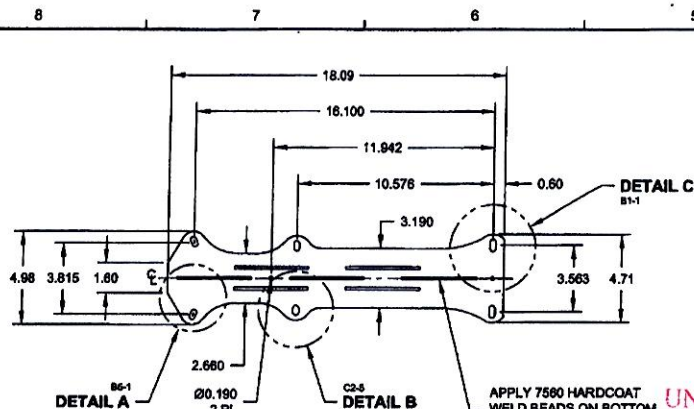
DART AEROSPACE LTD		Work Order:	151958
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

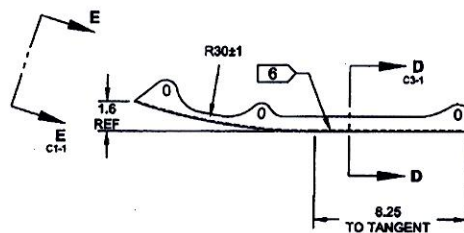
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	Ø.189	✓		V-drool	
Ø0.500	+0.006/-0.001	Ø.505	✓		Typ	
0.316	+/-0.010	.315	✓			
0.607	+/-0.010	.607	✓			
2.94	+/-0.030	2.94	✓			
2.69	+/-0.030	2.69	✓			
3.527	+/-0.010	3.530	✓			
4.52	+/-0.030	4.52	✓			
5.063	+/-0.010	5.064	✓			
6.16	+/-0.030	6.16	✓			
0.60	+/-0.030	.60	✓			
8.690	+/-0.010	8.692	✓			
30.790	+/-0.010	30.790	✓			
52.88	+/-0.030	52.88	✓			
62.770	+/-0.010	62.770	✓			
74.420	+/-0.010	74.420	✓			
75.52	+/-0.030	75.52	✓			
0.050	+/-0.010	.049	✓			

Measured by:		Audited by:		Preliminary Approval:	
Date:	16/11/11	Date:	NOV 14 2016	Date:	

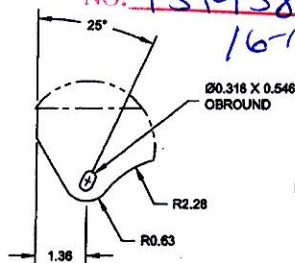
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



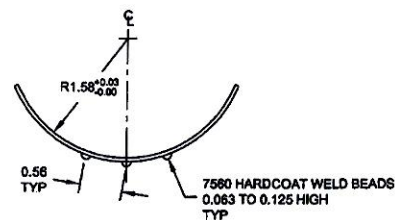
D3319-1F FLAT PATTERN



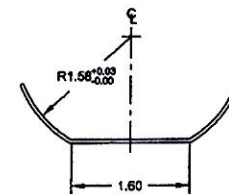
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



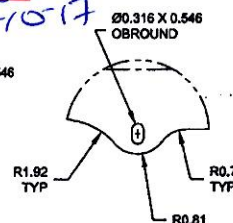
DETAIL A
SCALE 4X



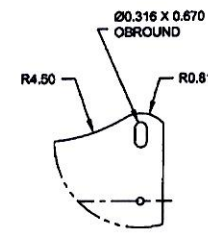
SECTION D-D
SCALE 4X



SECTION E-E
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

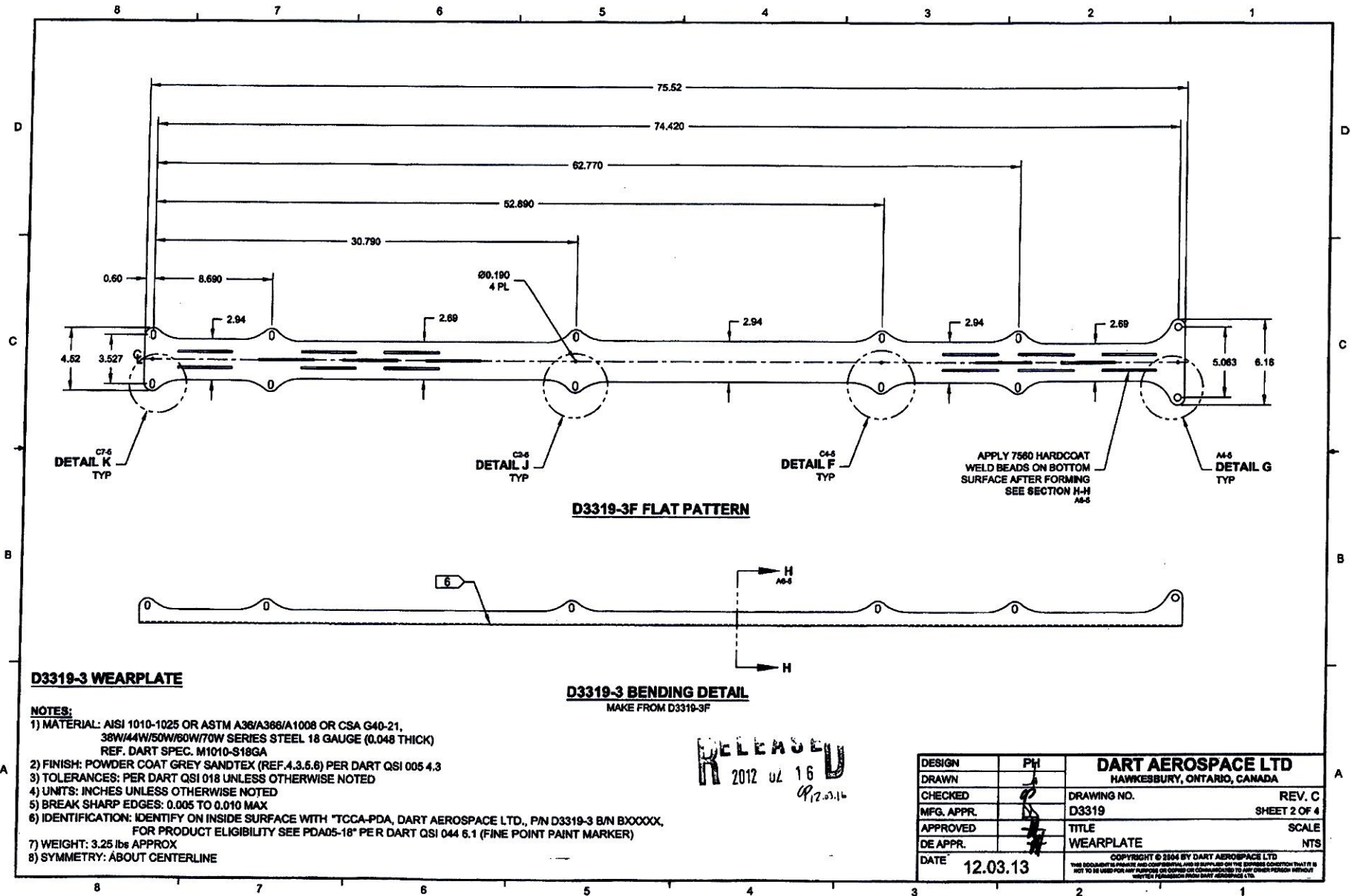
D3319-1 WEARPLATE

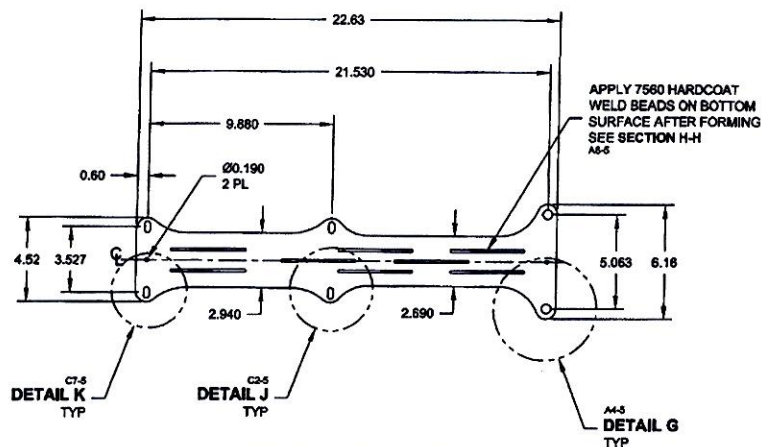
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

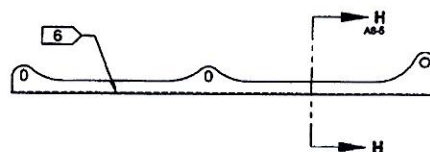
RELEASED
2012-03-16
PER ECN 12-946 R12-3.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT MOST HOLE ON -3/5-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D3319 TITLE WEARPLATE SCALE NTS	
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

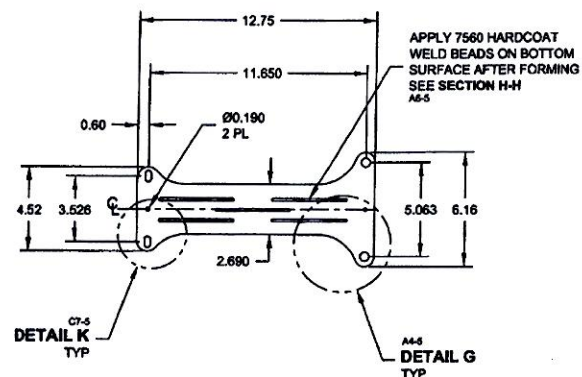




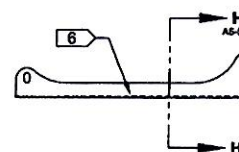
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

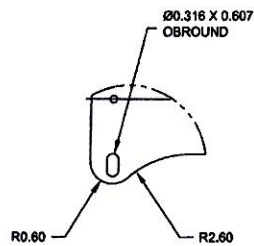
D3319-5/-7 WEARPLATE

NOTES:

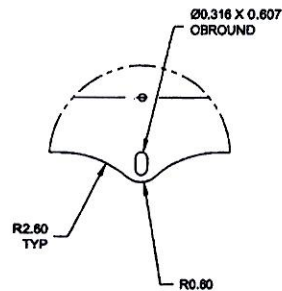
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16
4/12/13/16

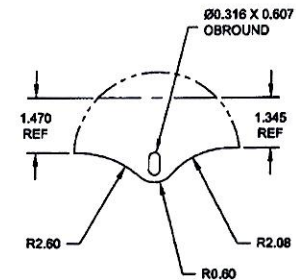
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 3 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.03.13		



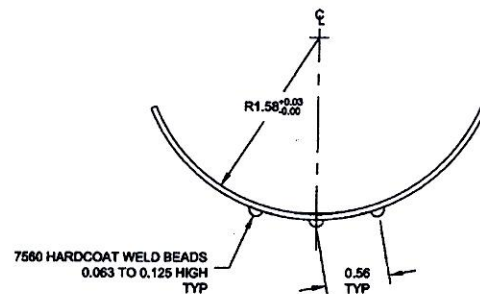
DETAIL K
SCALE 2X
B4-2
C4-3
C9-3



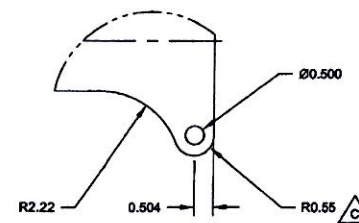
DETAIL F
SCALE 2X
B3-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B4-2
C2-3
C8-3

RELEASED
2012-02-16
P.2.05.16

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 4 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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